

Work Order ID 74788

74788

Page 1

October 6, 2011 1:37:33 PM

Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, LH
 Start Date: 10/06/11 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/17/11 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 11/10/00 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	Rev E								

100 0.00
100 Large Fab
 Large Fab Memo 0.00
 Large Fab 1-Cut D2622 extrusion as per Dwg D3562
 2-Deburr, and bevel ends for welding

11.11.17 4 0

110 0.00
110 QC6- Inspect dimensions to drawing
 QC Memo 0.00
 Quality Control

See 11.17 70

120 0.00
120 Chemical Conversion Coat per QSI005 4.1
 HandFinish Memo 0.00
 Hand Finishing

11.11.17 4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>4</u>	<u>16</u>	<u>11-18</u>	
140 *140* Small Fab Small Fab	Small Fab Memo 1- Transfer drill Rivet holes as per dwg D3562. 2-Touch-up rivet holes with alodine as per dwg d3562 3-Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: <u>117870</u>	0.00 0.00				<u>4</u>	<u>0</u>		<u>11-11-21</u>
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>(x9)</u>			<u>-01</u>

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N900040100

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Revision ID:

Stop *NS2*

Item Name: Step Assembly, LH

Start Date: 10/06/11 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 10/17/11 **Req'd Qty:** 4.00

4

Customer: .

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 0.00

160 Large Fab *11 11 22 4 2*

[illegible]

Large Fab 1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as

Memo

1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod j14514

2-Grind end cap welds flush as per Dwg D3562

170	QC10- Inspect visual per QSI004- ground welds	0.00
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170

QC	Memo	0.00	5/11/25				
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Quality Control

180	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

180

[illegible]

Quality Control

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October 6, 2011 1:37:33 PM

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Page 4

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190 Chemical Conversion Coat per QSI005 4.1 0.00

190

HandFinish

Hand Finishing

Memo

0.00

4X M-L M/M/25
LH

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

200

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

9:30
3200F
10:00

4X M-L M/M/28
LH

210 Wing Walk as per dwg QSI005 4.4 Batch _____ 0.00

210

HandFinish

Hand Finishing

Memo

0.00

4 BL 11-11-28

W/O:		WORK ORDER CHANGES					
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October 6, 2011 1:37:33 PM

Page 5

u 11.11.30

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October 6, 2011 1:37:39 PM

74788

D3562-041

Start Date: 10/06/11**Required Date:** 10/17/11

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP Rev:A	New Issue	06-11-09	JLM
	IPP rev B	ECN 987	07.10.09	EC verified by: DD
	IPP Rev:C	ECN1048	07-12-18	DD verified by:ec
	IPP Rev:D	08-07-28	add chemical conversion coat	DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	120.2000	1	4			
D2622-120C										**			
Step Extrusion													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				HALL			110.5						
				64409			6						
				68293			0.5						
				<u>72131</u>			104						
				WA			9.7						
				46910			2						
				66970			7.7						
D2734		Manufactured	No			140	Each	96.0000	2	8			
D2734										**			
Step End Plate													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			96						
				73196			36						
				<u>73416</u>			60						
D3560-041		Manufactured	No			140	Each	1.0000	1	4			
D3560-041										**			
Arm Weldment													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			1						
				<u>374803</u>			1						
				71568			1						

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Picklist Print

October 6, 2011 1:37:39 PM

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Parent Item: D3562-041

D3562-041

Parent Item Name: Step Assembly, LH

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

D3560-043

Manufactured No

140

Each

4.0000

1

4

11.11.19

D3560-043

Arm Weldment

Location

Loc Qty

Loc Code

WA

4

71949

4

4

MS20600-AD4W5

Purchased

No

160

Each

743.0000

32

128

11.11.19

MS20600-AD4W5

Blind Rivet

Location

Loc Qty

Loc Code

ST321

737

114382

173

117505

200

118384

364

128

WA018

6

111477

6

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NOTE: Date & initial all entries

D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

D3560-043 ARM WELDMENT

D3560-041 ARM WELDMENT

D3560-044 ARM WELDMENT

D3560-042 ARM WELDMENT

D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

TRANSFER DRILL #30
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING
(32 PLACES PER STEP)

REFER TO STEP
END DETAIL

INSTALL MS20600AD4W5 RIVET
(32 PLACES PER STEP)

SHOULDER MEASURED BEFORE END CAPS WELDED IN PLACE

MEASURED BEFORE END CAPS WELDED IN PLACE

RETURN TO
FWD

FWD

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 74788 M.L.J

11/10/06

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

D2734 END PLATE
(TYP 2 PLACES)

TYPICAL STEP END DETAIL
SCALE 1:2

D3562-041 LH STEP ASSEMBLY

D3562-042 RH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR
BLACK SANDTEX (4.3.5.7) OR
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808. REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	90		
CHECKED	LE		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3562** REV. E
SHEET 1 OF 1
TITLE **STEP ASSEMBLY** SCALE 1:5

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